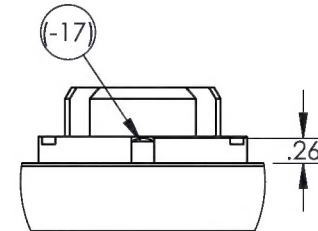
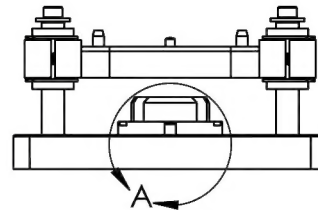
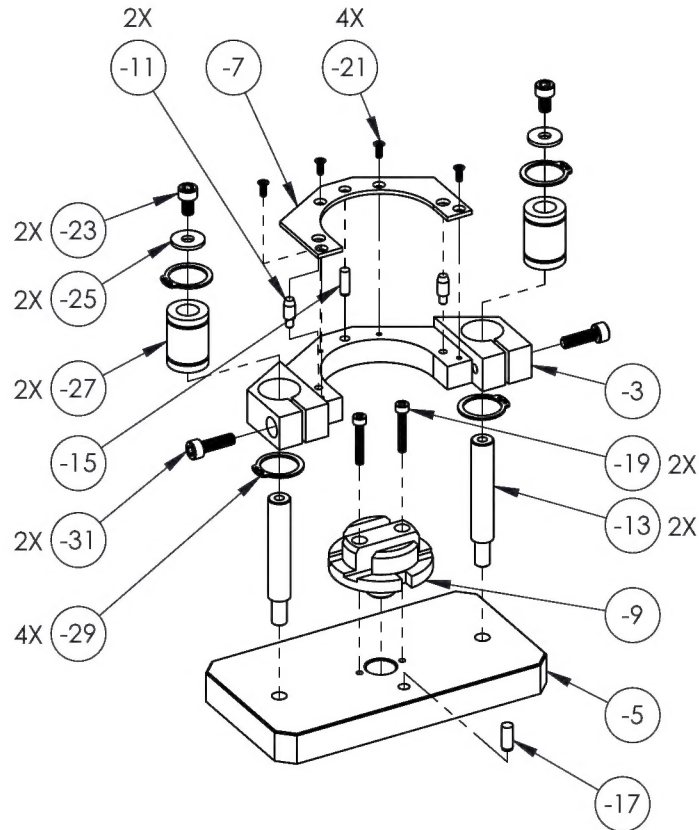
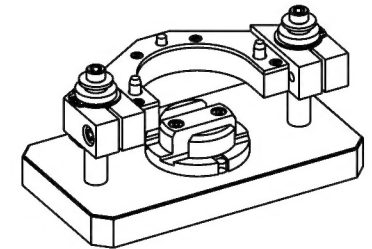


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DETAIL A  
SCALE 1 : 2

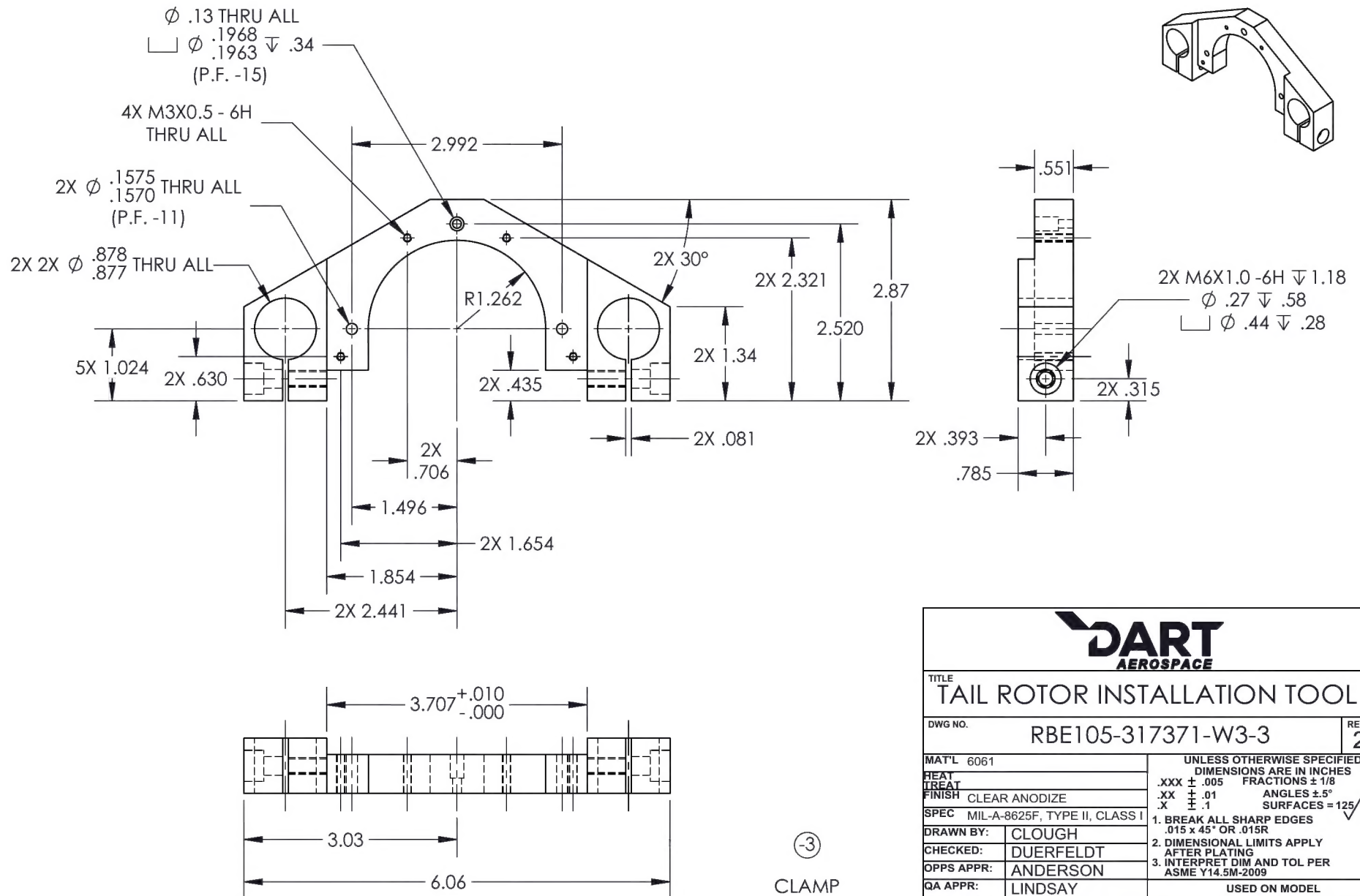


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0038	-3 CH'D DIM'S WAS Ø.098 THRU M3X.5 $\nabla$ .331 IS 4X M3X0.5-6H THRU ALL. WAS Ø.125 THRU C.B. Ø.1972/.1969 $\nabla$ .336 IS Ø.13 THRU ALL $\nabla$ .1968/.1963 $\nabla$ .34 (P.F. -15). WAS 2X 1.339 IS 2X 1.34. WAS 2X Ø.266 $\nabla$ .591 $\nabla$ .443 $\nabla$ .280 IS 2X M6X1.0-6H $\nabla$ .18 $\nabla$ .27 $\nabla$ .58 $\nabla$ .44 $\nabla$ .28. WAS 2X .394 IS 2X .393. WAS 6.063 IS 6.06. WAS 2.867 IS 2.87. WAS 2X Ø.1578/.1573 THRU IS 2X Ø.1575/.1570 THRU ALL. DELETED DIM'S 2X .591. 1.178. ADDED DIM'S 1.854. 3.707 +.010/- .000. 3.03. 2.992. -5 CH'D DIM'S WAS 4X .335 X 45° IS 4X .34 X 45°. WAS 2X Ø.3143/.3138 IS 2X Ø.3143/.3138 THRU ALL (P.F. -13). WAS 3.543 IS 3.54. WAS .610 IS .61. WAS Ø.6300/.6295 P.F. -13 CHAMFER .03 IS Ø.630/.629 THRU ALL $\nabla$ .69 X 90° NEAR SIDE (S.F. -9). WAS Ø.125 THRU $\nabla$ .2362/.2357 $\nabla$ .364 IS Ø.13 THRU ALL $\nabla$ .2362/.2357 $\nabla$ .36 (P.F. -17). WAS .709 IS .71. WAS 6.535 IS 6.54. DELETED DIM 5X 1.575. ADDED DIM'S 5X .965. 8X .03 X 45°. -7 CH'D DIM'S WAS Ø.238 IS .24 THRU ALL. WAS 2X Ø.277 IS 2X Ø.28 THRU ALL (S.F. -11). WAS 2.432 IS 2.43. WAS 2X .589 IS 3X .589. WAS 3.701 IS 3.701 +.000/- .010. WAS 4X Ø.128 THRU $\nabla$ .424 $\nabla$ .016 $\nabla$ .242 X 90° $\nabla$ .057 IS 4X Ø.13 THRU ALL $\nabla$ .25 X 90°. WAS .079 IS .094. DELETED DETAIL A. -9 CH'D DIM'S WAS 2X Ø.173 THRU $\nabla$ .317 $\nabla$ .174 IS 2X Ø.18 THRU ALL $\nabla$ .32 $\nabla$ .17. WAS .512 IS 3X .512. WAS .554 IS (.554). WAS Ø.6295/.6290 P.F. -7 IS Ø.6278/.6271 (S.F. -5). WAS .081/.079 IS 2X .081/.079. WAS .118 X 30° IS .12 X 30°. WAS .049 X 45° IS .05 X 45°. DELETED DIM .276. ADDED DIM 1.39. (.600). -23 CH'D B/O MATERIAL WAS STEEL IS S.S. -25 CH'D B/O DESCRIPTION WAS FLAT WASHER IS OVERSIZED FLAT WASHER. -29 CH'D QTY WAS 2 IS 4. CH'D B/O INFO WAS #97633A280 IS #98541A463. -31 CH'D B/O INFO WAS M6 X 16mm #91595A446 IS M6X1 X 20mm #90128A264.	2/10/2017	RJC	SM

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	NOTE: REF. EUROCOPTER 105-317371W3.	
			-3	1	CLAMP	6061		2		
			-5	1	BASE	6061		3		
			-7	1	PLATE	PHENOLIC		4		
			-9	1	ADAPTER	WHITE DELRIN/ACETAL		5		
		B/O	-11	2	ALIGNMENT PIN	01	Ø4mm MiSUMi #FPBA4-P6-L6-B8	1		
		B/O	-13	2	GUIDE	5210	Ø12mm MiSUMi #SFNA12-60-F16-P8-N6	1	<b>TITLE</b> TAIL ROTOR INSTALLATION TOOL	
		B/O	-15	1	DOWEL PIN	STEEL	M5 X 16mm (MCMaster-CARR #91595A352)	1	<b>DWG NO.</b> RBE105-317371-W3	
		B/O	-17	1	DOWEL PIN	STEEL	M6 X 16mm (MCMaster-CARR #91595A446)	1	<b>REV</b> 2	
		B/O	-19	2	SOCKET HEAD CAP SCREW	STEEL	M4 X 0.7mm X 25mm (MCMaster-CARR #91760A162)	1	<b>MAT'L</b> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
		B/O	-21	4	FLAT HEAD SCREW	STEEL	M3 X 0.5mm X 8mm (MCMaster-CARR #91420A118)	1		
		B/O	-23	2	SOCKET HEAD CAP SCREW	S.S.	M6 X 1 X 10mm (MCMaster-CARR #92290A316)	1		
		B/O	-25	2	OVERSIZED FLAT WASHER	STEEL	M6 X 18mm O.D. (MCMaster-CARR #9100A150)	1		
		B/O	-27	2	LINEAR BEARING	STEEL	Ø12mm I.D. X 22mm O.D. X 32mm APPLIED IND. # KSO12-PP	1		
		B/O	-29	4	EXTERNAL RETAINING RING	STEEL	Ø22mm SHAFT (MCMaster-CARR #98541A463)	1	<b>USED ON MODEL</b> EC145	
		B/O	-31	2	SOCKET HEAD CAP SCREW	STEEL	M6 X 1 X 20mm (MCMaster-CARR #90128A264)	1	<b>SCALE</b> 1:4 <b>DATE</b> 8/26/2010 <b>SHEET</b> 1 OF 6	
<b>DRAWN BY:</b> CLOUGH <b>CHECKED:</b> DUERFELDT <b>OPPS APPR:</b> ANDERSON <b>QA APPR:</b> LINDSAY <b>APPROVED:</b> MACKOVJAK										

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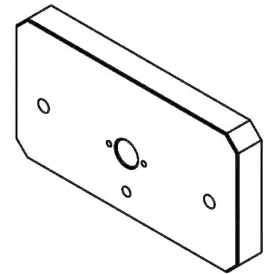
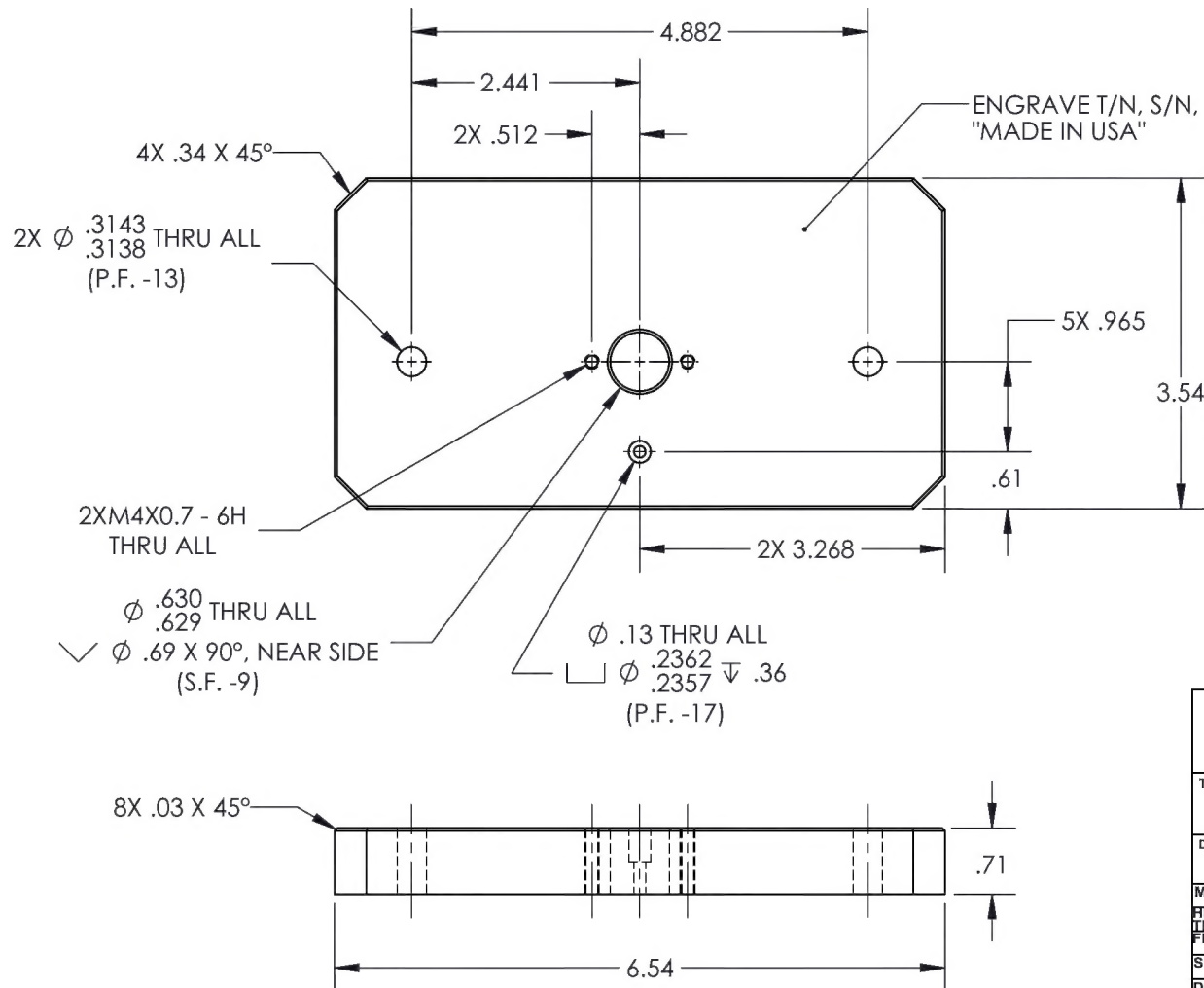
REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	17-0038	-3 CH'D DIM'S WAS Ø.098 THRU M3X.5 ▽.331 IS 4X M3X0.5 -6H THRU ALL, WAS Ø.125 THRU C.B. Ø.1972/.1969 ▽.336 IS Ø.13 THRU ALL ▽ Ø.1968/.1963 ▽.34 (P.F. -15), WAS 2X 1.339 IS 2X 1.34, WAS 2X Ø.266 ▽.591 ▽ Ø.443 ▽.280 IS 2X M6X1.0 -6H ▽1.18 Ø.27 ▽.58 ▽ Ø.44 ▽.28, WAS 2X .394 IS 2X .393, WAS 6.063 IS 6.06, WAS 2.867 IS 2.87, WAS 2X Ø.1578/.1573 THRU IS 2X Ø.1575/.1570 THRU ALL, DELETED DIM'S 2X .591, 1.178. ADDED DIM'S 1.854, 3.707 +.010/-.000, 3.03, 2.992.	2/10/2017	RJC	SM	



<b>DART</b> AEROSPACE	
TITLE <b>TAIL ROTOR INSTALLATION TOOL</b>	
DWG NO. <b>RBE105-317371-W3-3</b>	REV <b>2</b>
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
FINISH CLEAR ANODIZE	.XX $\pm$ .01 ANGLES $\pm$ 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X $\pm$ .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EC145
SCALE 1:2	DATE 8/26/2010
SHEET 2 OF 6	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	17-0038	-5 CH'D DIM'S WAS 4X .335 X 45° IS 4X .34 X 45°, WAS 2X Ø.3143/.3138 IS 2X Ø.3143/.3138 THRU ALL (P.F. -13), WAS 3.543 IS 3.54, WAS .610 IS .61, WAS Ø.6300/.6295 P.F. -13 CHAMFER .03 IS Ø.630/.629 THRU ALL ✓ Ø.69 X 90° NEAR SIDE (S.F. -9), WAS Ø.125 THRU L Ø.2362/.2357 ▽.364 IS Ø.13 THRU ALL L Ø.2362/.2357 ▽.36 (P.F. -17), WAS .709 IS .71, WAS 6.535 IS 6.54, DELETED DIM 5X 1.575. ADDED DIM'S 5X .965, 8X .03 X 45°.	2/10/2017	RJC	SM	

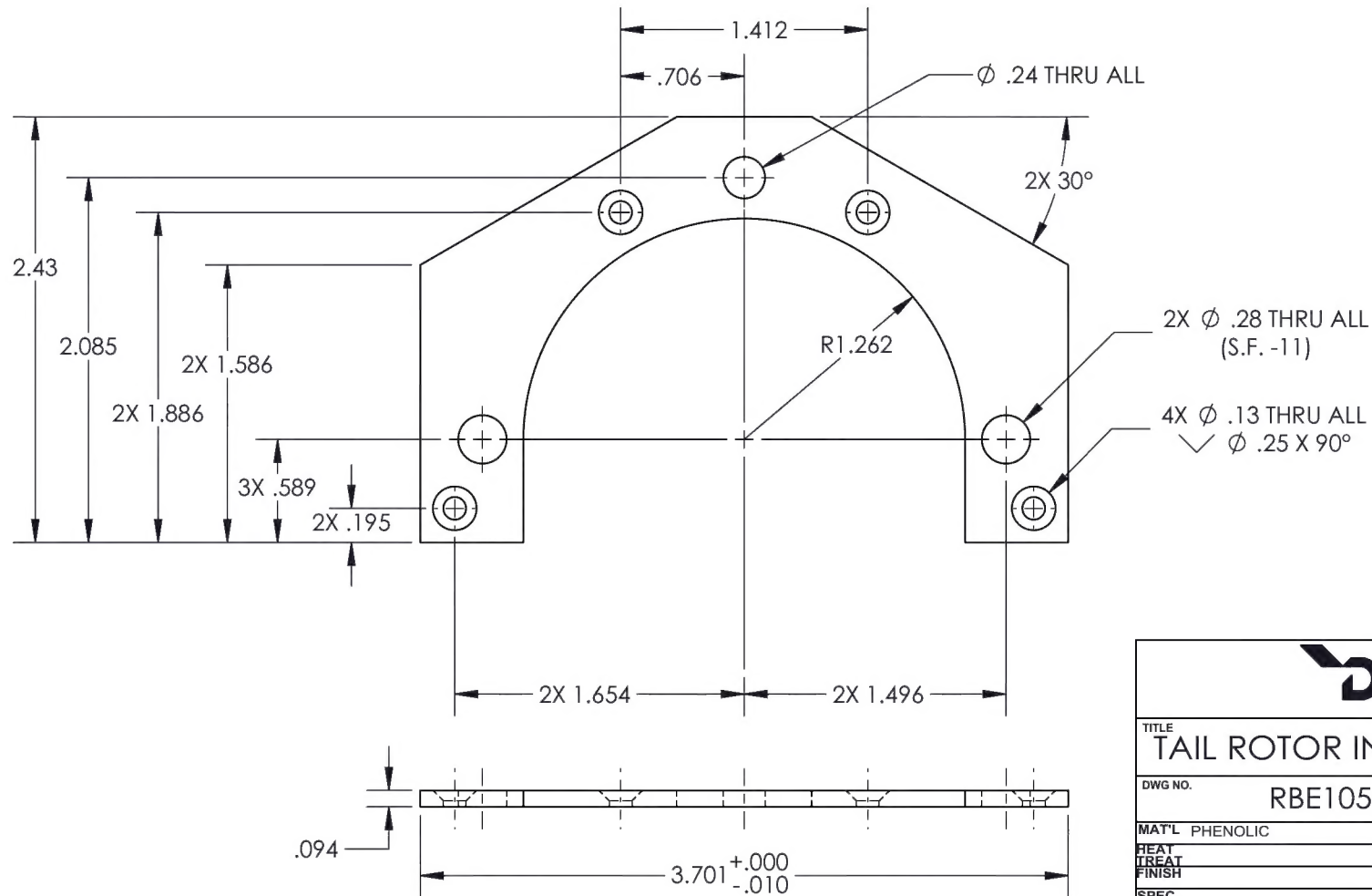


⑤  
BASE

<b>DART AEROSPACE</b>	
TITLE <b>TAIL ROTOR INSTALLATION TOOL</b>	
DWG NO. <b>RBE105-317371-W3-5</b>	REV <b>2</b>
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EC145
SCALE 1:2	DATE 8/26/2010
SHEET 3 OF 6	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	17-0038	-7 CH'D DIM'S WAS Ø.238 IS .24 THRU ALL, WAS 2X Ø.277 IS 2X Ø.28 THRU ALL (S.F. -11), WAS 2.432 IS 2.43, WAS 2X .589 IS 3X .589, WAS 3.701 IS 3.701 +.000/-0.010, WAS 4X Ø.128 THRU ALL  Ø.424  .016  Ø.242 X 90°  .057 IS 4X Ø.13 THRU ALL  Ø.25 X 90°, WAS .079 IS .094. DELETED DETAIL A.			2/10/2017	RJC	SM



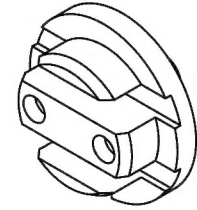
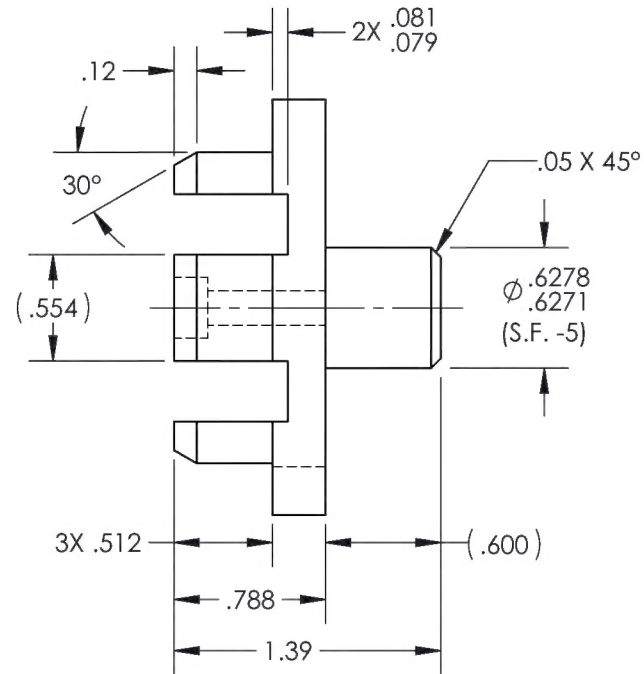
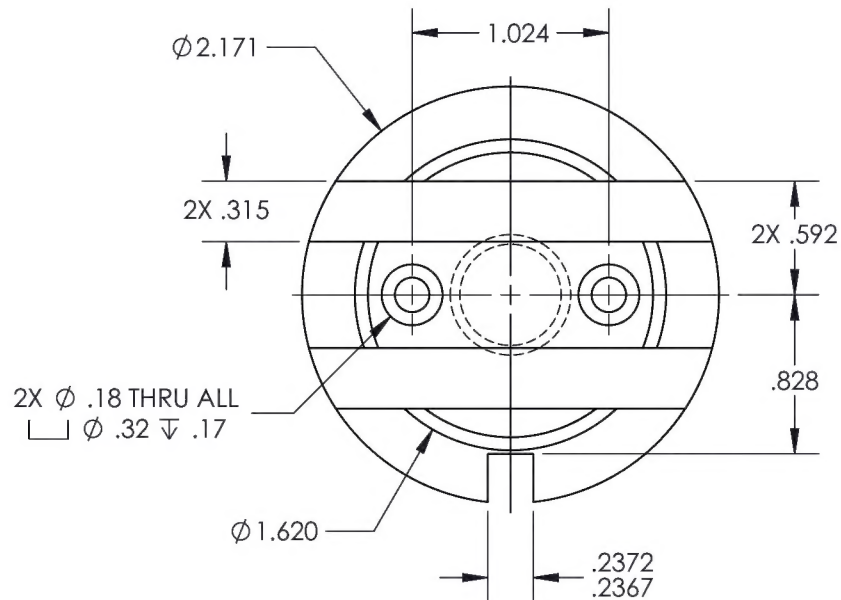
(-7)  
PLATE

<b>DART AEROSPACE</b>	
TITLE <b>TAIL ROTOR INSTALLATION TOOL</b>	
DWG NO. <b>RBE105-317371-W3-7</b>	REV <b>2</b>
MAT'L PHENOLIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT TREAT FINISH	.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	EC145
APPROVED: MACKOVJAK	
SCALE 1:1	DATE 8/26/2010
SHEET 4 OF 6	



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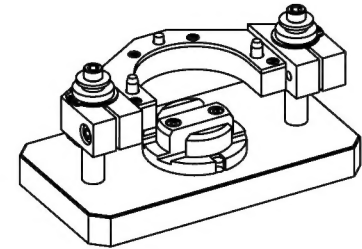
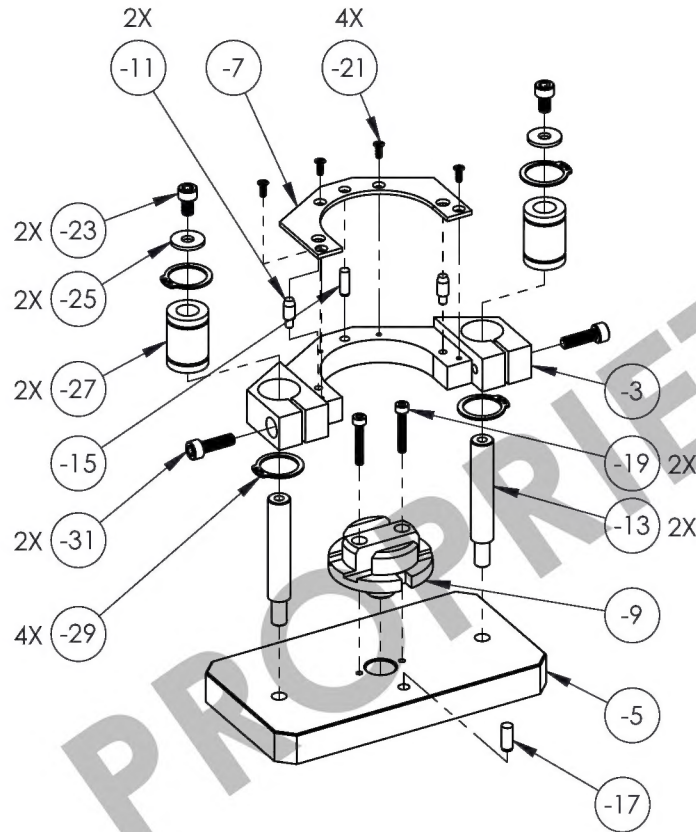
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0038	-9 CH'D DIM'S WAS 2X Ø.173 THRU L L Ø.317 $\nabla$ .174 IS 2X Ø.18 THRU ALL L L Ø.32 $\nabla$ .17, WAS .512 IS 3X .512, WAS .554 IS (.554), WAS Ø.6295/.6290 P.F. -7 IS Ø.6278/.6271 (S.F. -5), WAS .081/.079 IS 2X .081/.079, WAS .118 X 30° IS .12 X 30°, WAS .049 X 45° IS .05 X 45°. DELETED DIM .276. ADDED DIM 1.39, (.600).	2/10/2017	RJC	SM



(-9)  
ADAPTER

<b>DART AEROSPACE</b>	
TITLE <b>TAIL ROTOR INSTALLATION TOOL</b>	
DWG NO. <b>RBE105-317371-W3-9</b>	REV <b>2</b>
MAT'L WHITE DELRIN/ACETAL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
FINISH	.XX $\pm$ .01 ANGLES $\pm$ 5°
SPEC	.X $\pm$ .1 SURFACES = 125 $\sqrt$
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EC145
SCALE 1:1	DATE 8/26/2010
SHEET 5 OF 6	

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Part #	UNIT QTY	Description	Material
-3	1	CLAMP	6061
-5	1	BASE	6061
-7	1	PLATE	PHENOLIC
-9	1	ADAPTER	WHITE DELRIN/ACETAL
-11	2	ALIGNMENT PIN	01
-13	2	GUIDE	5210
-15	1	DOWEL PIN	STEEL
-17	1	DOWEL PIN	STEEL
-19	2	SOCKET HEAD CAP SCREW	STEEL
-21	4	FLAT HEAD SCREW	STEEL
-23	2	SOCKET HEAD CAP SCREW	S.S.
-25	2	OVERSIZED FLAT WASHER	STEEL
-27	2	LINEAR BEARING	STEEL
-29	4	EXTERNAL RETAINING RING	STEEL
-31	2	SOCKET HEAD CAP SCREW	STEEL



**AEROSPACE**  
 190 S. Danebo Ave., Eugene, OR. 97402  
 1-800-556-4166  
 e-mail: sales@dartaero.com  
 dartaerospace.com

TITLE TAIL ROTOR INSTALLATION TOOL			
DWG NO. RBE105-317371-W3	REV 2	CUSTOMER 1 OF 1	
SCALE 1:4	DATE 8/26/2010	SHEET 6 OF 6	